

Work Order ID 70670

Monday, June 13, 2011 1:10:23 PM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 6/13/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 6/13/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-6-16

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

0.00

Quality Control

Memo

B11-6-16

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 wlog 16

47

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M115778

11.07.06

2

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.07.06

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Smash

27

-041

170

Identify as per dwg & Stock Location: WAS

0.00



Packaging

Memo

0.00

Packaging

1107.06

7

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11

ME
11-07-07

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Picklist Print

Monday, June 13, 2011 1:10:20 PM

Page 1

Work Order ID: 70670

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

127.0000

0.45

2.842105



304/316 0.125 Sheet



1311-6-16

Location

Loc Qty

Loc Code

MAT020

127

117494

127

117494

9

D3907-1

Manufactured

No

130

Each

30.0000

2

12



Bushing



11.07.06

Location

Loc Qty

Loc Code

WA005

30

65920

4

66090

26

14

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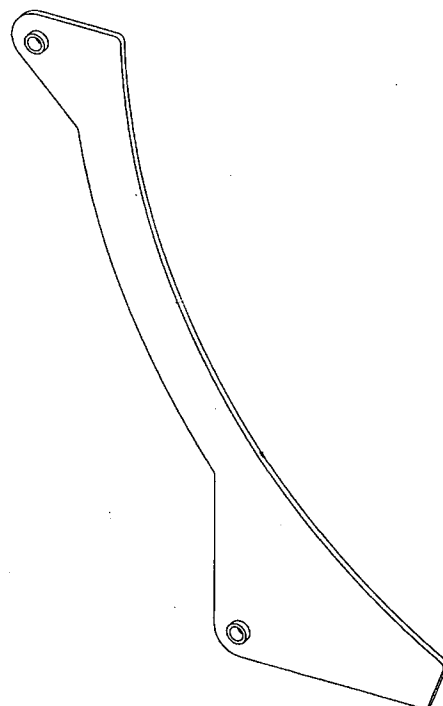
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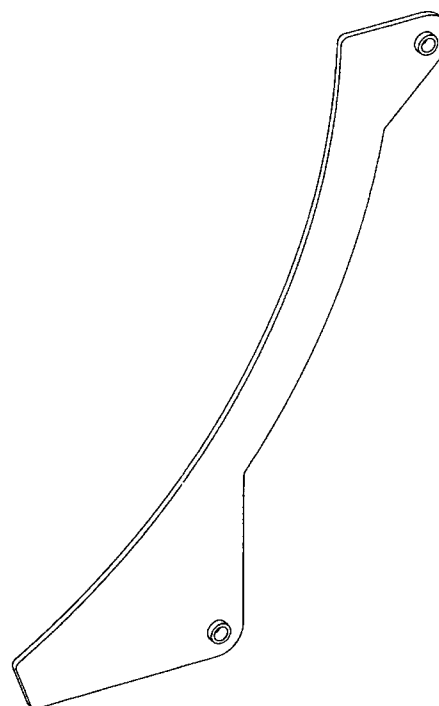
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

CL11106113
W10,70670

RELEASED
09/04/03

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03	
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3929	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.			GUSSET ASSEMBLY	NTS
DATE	09.04.03		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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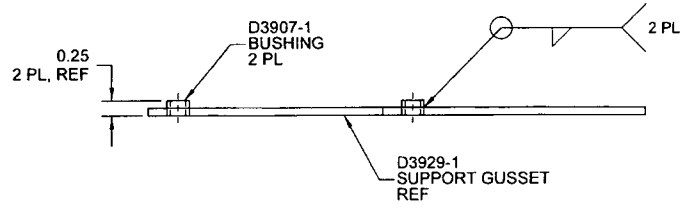
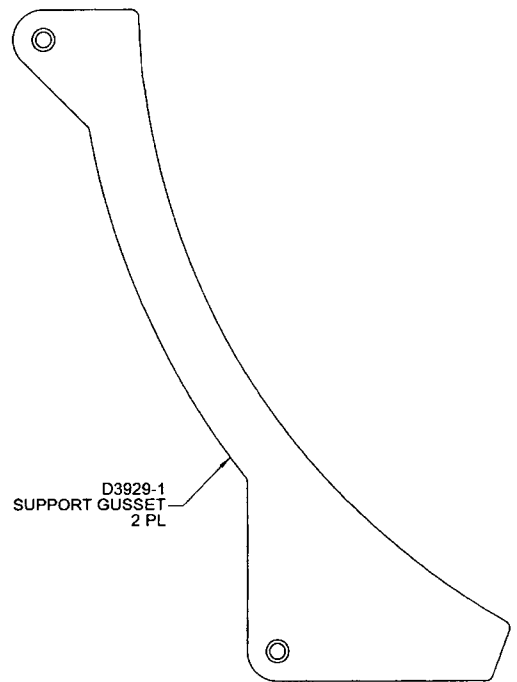
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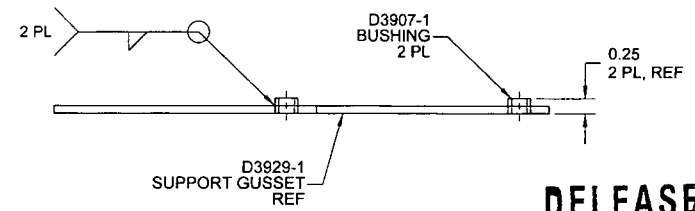
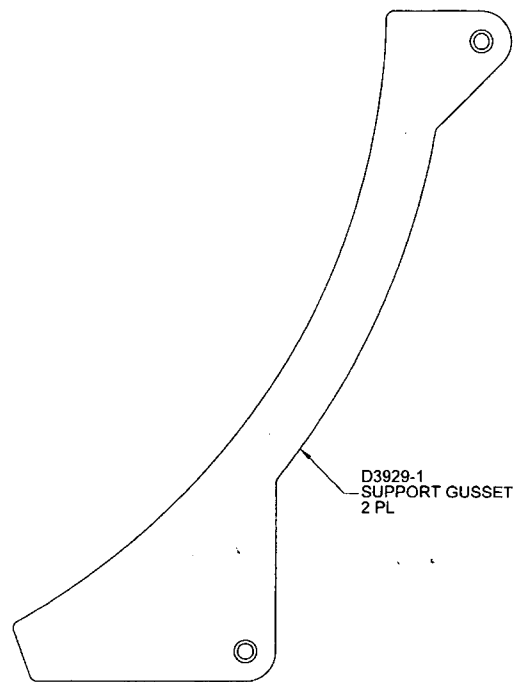
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B

A



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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